

Date: Monday, 11/14/2005 2:38:50 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 L HIGH GEAR SKIDTUBE
Job Number :	24739		
Estimate Number :	10522		
P.O. Number :	N/A	Part Number :	D206642441
This Issue :	11/14/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2650 REV D1
First Issue :	N/A	Project Number :	N/A
Previous Run :	24521A	Drawing Revision :	D1
Written By :	SEE COMMENT BELOW	Material :	
Checked & Approved By :	SEE ABOVE USER & DATE	Due Date :	11/30/2005
Comment :	Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441CHG002

DH
Rec'd paperwork 06/03/09

2.0	D2620	Bent 206 Skidtube
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B24497

DP05-12-1

3.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B20535 BE 05-12-1

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

DP05-12-1

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DP05-12-1

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M 18901 BE 05-12-1

4-Grind weld flush to cap on top surface only.

BE 05-12-1

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5-Cut aft end 138.60" from front of tube

BE 05-12-1

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to $\emptyset 0.312$ ".

BE 05-12-1

7-Drill holes for wearplates using DT 8028-7. Open to $\emptyset 0.297$ ".

BE 05-12-1

8-Open using #6 Drill Bit

BE 05-12-1 est. updated 05.12.01

9-Open holes for Tow Ring to $\emptyset 0.625$ " as per Dwg D2650, D2650-7 Drilling Detail

BE 05-12-1

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

DP 05-12-2

11-Deburr and Blow out all chips from inside the tube

DP 05-12-2

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 05-12-05

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B25107

A.M 05-12-07

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

DP 05-12-7

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

DP 05-12-7

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

DP 05-12-7

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 05-12-07 Time: 1:00

Finish Date: 05-12-12 Time: 1:00

A/R Sikaflex-291 M18467

Sikaflex expiry date: 05-12-01

A.M 05-12-08

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

8.0

QC5

INSPECT WORK TO CURRENT STEP



2-05-12-08

Comment: INSPECT WORK TO CURRENT STEP

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

324200 BE 05-12-12

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

mk5855

BE 05-12-12

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

DP 05-12-13

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

DP 05-12-13

11.0

D2682041

Support Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B 21123 BE 05-12-13

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

mk2548 BE 05-12-13

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	M7885343	Rivet
------	----------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M 7808 BE 05-12-13

14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

BE 05-12-13

15.0	QC5/9	WELD INSPECTION
------	-------	-----------------



Comment: WELD INSPECTION

MO5/12/13

20-12-14

16.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

aim 06-03-01

Make sure Nut Plate Thread protected use paint screw

17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

06 03 07

18.0	D26483	Wearpad
------	--------	---------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B248-13

FL

06 03 07

19.0	D265615	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B21712

FL

06 03 07

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B22085

FC

21.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B23558

FC

22.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

D24412

FC

23.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

M18293

or (see QSI 017)

FC

24.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M19185

FC 06 03 07

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
60	MS27039-1-08	Screw	<u>m169411</u>

FC

26.0	D26511	Plug
------	--------	------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
22	D2651-1	Plugs	<u>B25010</u>

FC

27.0	D26513	O-Ring
------	--------	--------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
22	D2651-3	O-Rings	<u>B23491</u>

FC

28.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416	Washer	<u>m11151</u>

FC

29.0	MS27039406	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS27039-4-06	Screw	<u>m6874</u>

FC 06 03 07

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

30.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	20208

FC

31.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD10L	Washer	m19185

FC

32.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS27039-1-08	Screw	m16441

FC

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. FC

A/R Sikaflex-291 m14597
Sikaflex expiry date: 06 18 06

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive FC

3-Install MS27039-4-06 Screw as per DEO 9153 FC

4-Inspect for foreign object per QSI 024 FC

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive FC

A/R Sikaflex-291 m19597
Sikaflex expiry date: 06 18 06

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: m10037

FC 06 03 08

Date: Monday, 11/14/2005 2:38:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24739

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

M 06 03 08

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *2*

*package for PP
REV. F*

C 206/03/09 ①

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PP 06/03/13 ①

Job Completion



U 06.03.09

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am


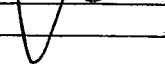
Work Order No	:	0024739	Department Code:	
Project Name	:	*D206-642-441	Burden Flags	: NNNNNNN
Project For	:	WK547	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	*D206-642-441	Invoice Number	:
Description	:	Replacement Skidtube	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	1	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-09-05		
Est Finish Date	:	11-24-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Date: Thursday, 11/10/2007 2:26:44 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642
Job Number : 35132	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 11/10/2007 S.O. No. :	Drawing Number : ECN 1046-PAPERWORK
Prsht Rev. : NC	Project Number :
First Issue : 11 Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 18/10/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D206-642-111 15614 15615
 D206-642-112 10319 25504
 D206-642-141 9375 18613
 D206-642-211 33078 32559-32565-33795-33776
 D206-642-212 32257 32567-32566-32568-33079-33080-33242
 D206-642-213 19735
 D206-642-214 24414-24484-28083-29084-32983-32984
 D206-642-241 28097-28604-33211-33342
 D206-642-311 28847
 D206-642-312 29741-15619-29742-29744
 D206-642-341 34557 34056-34555-34556-32495-31980
 D206-642-411 34132
 D206-642-411BL 34564-34563-34562-34060-34054-32502-34058
 D206-642-412 34735
 D206-642-412BL 34735
 D206-642-441 31066-30940-30260-30265-24739
 D206-642-511 34582-34579-33848-34581
 D206-642-512 34586-34584-34583
 D206-642-513
 D206-642-514
 D206-642-541
 D206-642-611
 D206-642-612

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1
 PER ECN 1046

1-11-07 SP